



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

UNDER REVIEW

URF18-745

D3512-041
Job Sheet 199381



Part No: D3512-041

Job Qty: 7 pcs

POSITIVE RECALL

Part Name: Wearplate



EFFECTIVE 19/11/27 AUTH SAH

Part Weight: 0 lbs

Status: New

RELEASED DD DATE 19-11-27

Job Created: 8/21/19

Job Tracking No:

Priority: Medium

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF18-745 DWG D3512 REV.D IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.11
ECN13-619/ REV.D DWG DD VERF:JLM IPP REV:C 18.03.12 DWG REV.E12 DD VERF:JFS IPP REV:D
18.10.12 BACK TO REV.D DD VERF:RG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	7 pcs	11/25/19	11/25/19	0.00	1.17	Large Fab - 1		ER
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	Large Fab - Welded Assy-2-B4B	7 pcs	11/25/19	11/25/19	0.00	1.17	Large Fab - 1 - B4B		ER
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
			11/25/19	0.00	0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
			11/25/19	0.00	0.00		QC 5 - 10		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S234251



Part: D3512--041

Job No: 199381

Serial No/Batch: S234251

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/22/19

Plex 11/22/19 11:56 AM dart.larocque.eric

pcs

142 Spray Paint - 2 - B4B 7 pcs 11/25/19 0.00 0.70

144 QC 5 7 pcs 11/25/19 0.00 0.00

150 Packaging 3-1 - Stock - B4B 7 pcs 11/25/19 0.00 0.00

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

Spray Paint - 1 - B4B

Spray Paint - 2 - B4B

Spray Paint - 3 - B4B

Spray Paint - 4 - B4B

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

DAS
24
9-89

• RD 19-11-25

DAS
40
9-89

NOV 27 2019

DAS
28
9-89

POSITIVE
RECALL

See
Part Drawn
DAS
9
9-89
ok to
release

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	7 pcs	11/25/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - Weld per dwg A/R Hardcoat S.S. Batch: 2059B HARDCOAT BATCH: <u>M139025</u> Descriptions: 120 - Weld per dwg A/R S.S. rod Batch: <u>M136585</u> 130 - QC9- Inspect visual per QSI004- Fusion Welds 140 - QC5- Inspect part completeness to step on W/O 142 - Assemble as per dwg - Coat wearplate with rockguard as per Dwg and note #10 Batch: <u>5227557</u> 144 - QC5- Inspect part completeness to step on W/O 150 - Identify as per dwg & Stock Location: <u>u</u> 160 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D3512-1	Wearplate	7 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>5222781</u>	
D3512-3	Spacer	7 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>5217469</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Large Fab - Welded Assy-1	D3512-1	7	7	0	
	D3512-3	7	13	0	
Part Specifications					
Specifications could not be found.					

Entered:

Date:

12 Dec 30/19



NCR No.

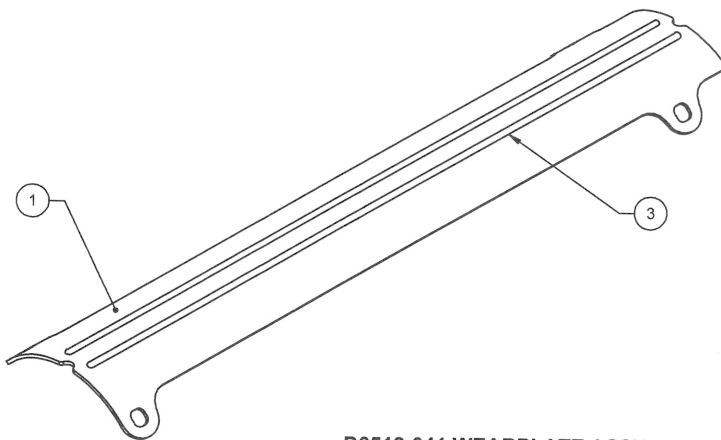
19-7783

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

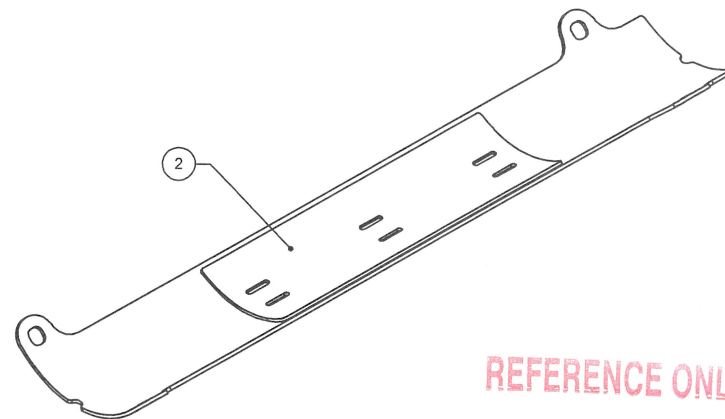
Route update only

Job: <u>199381</u> Part No. <u>D3512-041</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>19-11-27</u>		Sequence #: <u>100</u>		QTY Affected: <u>7</u>		MRB (QSI042) DAS 51 SM 9-89 19/11/27																													
Description Work Order Deviation				Disposition																															
minor change to Rev. D, flat Pattern for manufacturability, No change to final bent wearplate				Acceptable to make to Rev. E Ref w/o 193591																															
				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
				PD 19-11-27																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread																																
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																	
		Other/Details:																																	

ITEM	QTY	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	8259 \ 2059B	HARD SURFACING



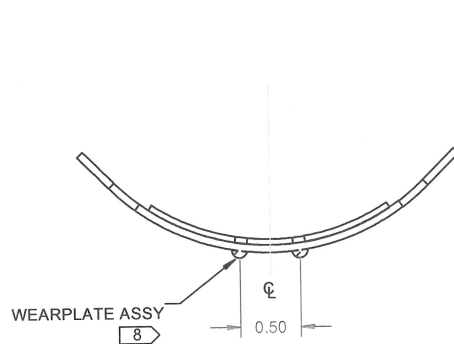
D3512-041 WEARPLATE ASSY



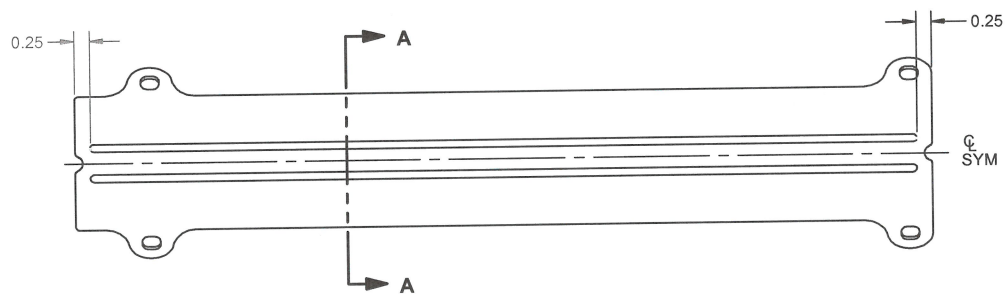
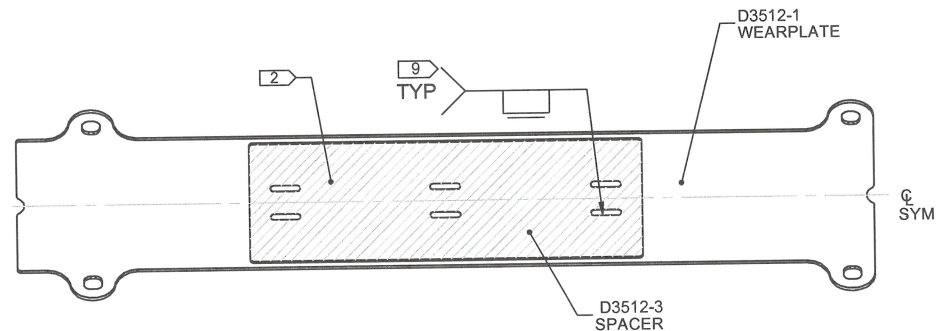
REFERENCE ONLY

E	ADJUSTED WIDTH OF PART FOR FIT AND FUNCTION, DIM 3.63 WAS 3.84 (ZN D3-3). UPDATE NOTE 8 (ZN A8-2). ADD NOTCHES (ZN D3-3 & D8-3). CHANGE SLOTS TO QTY 6 AND LENGTH TO 0.5 (ZN D4-4). GENERAL UPDATE OF DRAWING TO CURRENT STANDARDS.	SAD	18.03.07
D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	SAD		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	18.03.07	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

WORK IN PROGRESS



SECTION A-A 
SCALE 2X



D3512-041 WEARPLATE ASSY

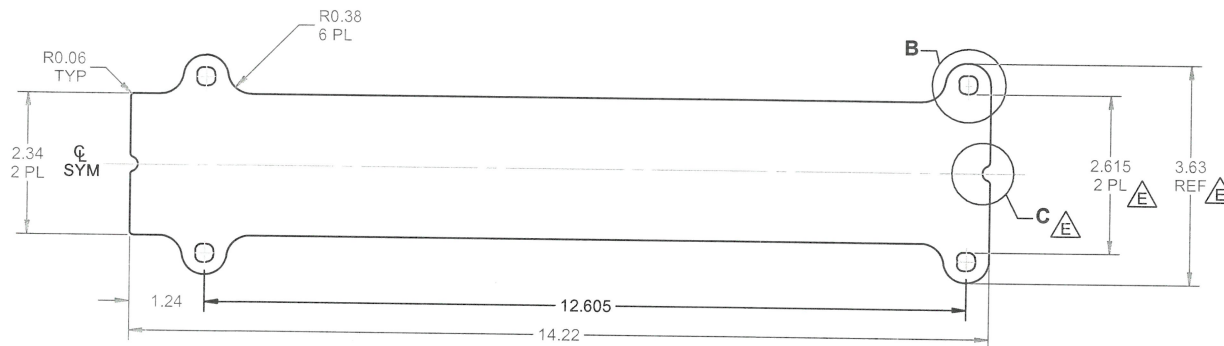
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NOTES:

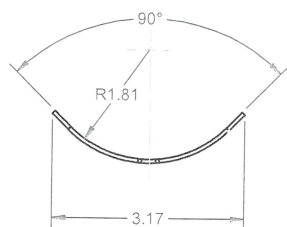
- 1) MATERIAL: N/A
- 2) FINISH: COAT HATCHED (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.87 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) WELD PER QSI 004

WORK IN PROGRESS

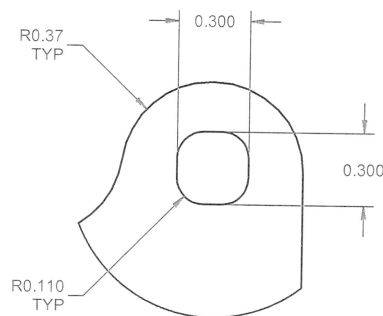
DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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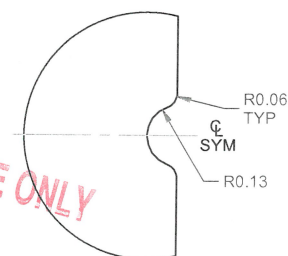
D3512-1F WEARPLATE
(FLAT PATTERN)



D3512-1 WEARPLATE
(MAKE FROM D3512-1F)



DETAIL B
SCALE 4X
4 PL



DETAIL C
SCALE 4X
2 PL

REFERENCE ONLY

WORK IN PROGRESS

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

D

C

B

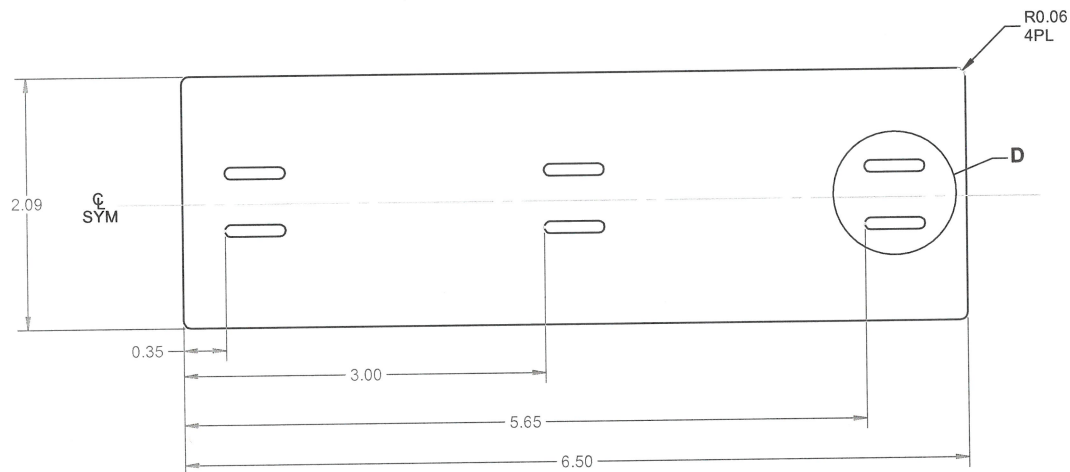
A

D

C

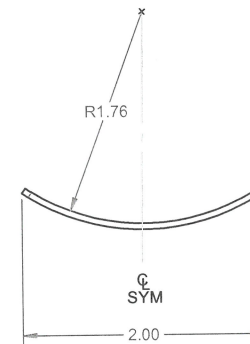
B

A

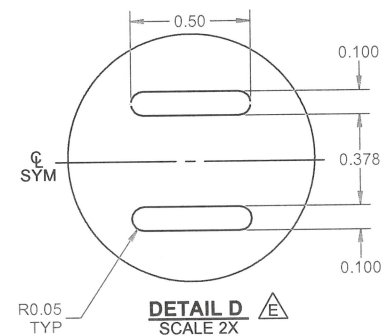


D3512-3F SPACER 
(FLAT PATTERN)

REFERENCE ONLY



D3512-3 SPACER
(MAKE FROM D3512-3F)



DETAIL D 
SCALE 2X
3 PL

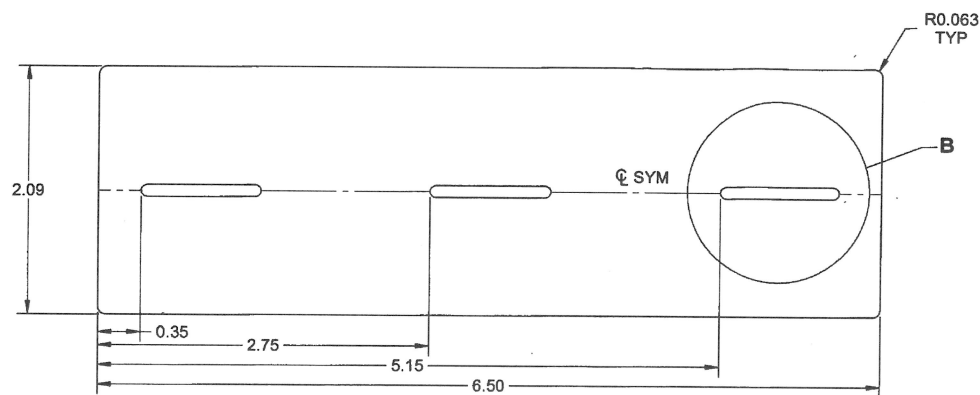
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

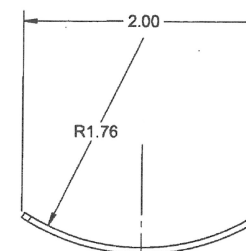
WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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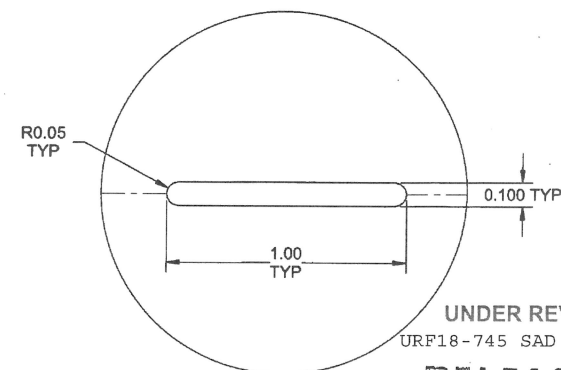
8 7 6 5 4 3 2 1



D3512-3F FLAT PATTERN



D3512-3 SPACER
MAKE FROM D3512-3F



DETAIL B
SCALE 2X

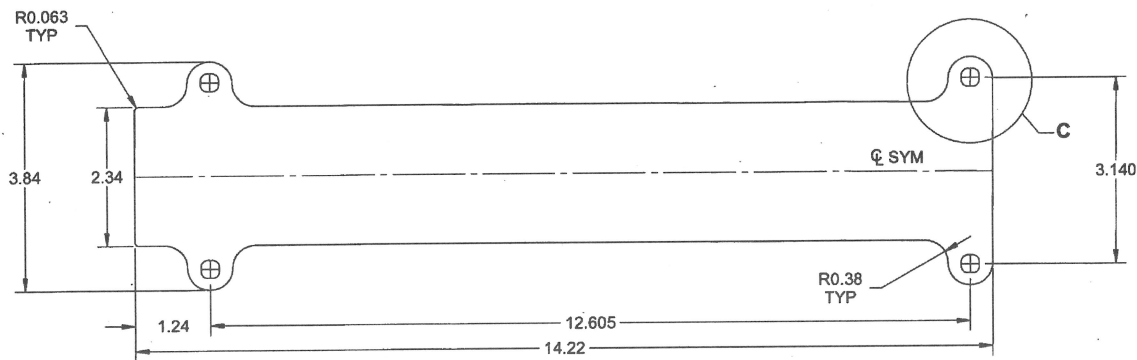
UNDER REVIEW
URF18-745 SAD 18-06-19

RELEASED
11 2013-12-10

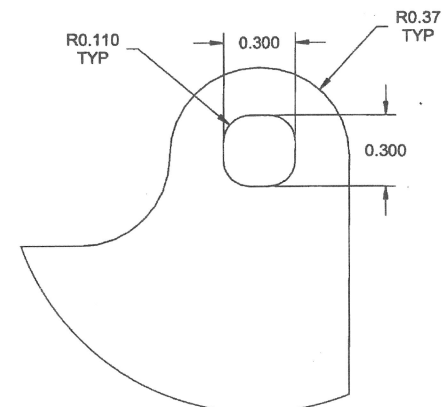
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3512-1F



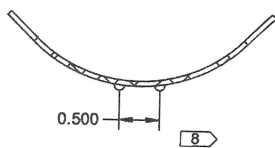
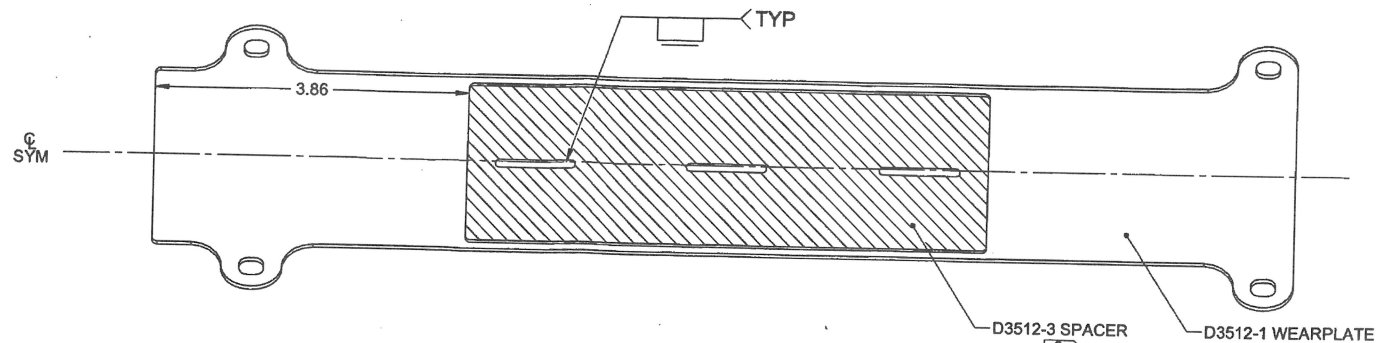
DETAIL C
SCALE 2X

UNDER REVIEW
URF18-745 SAD 18-06-19

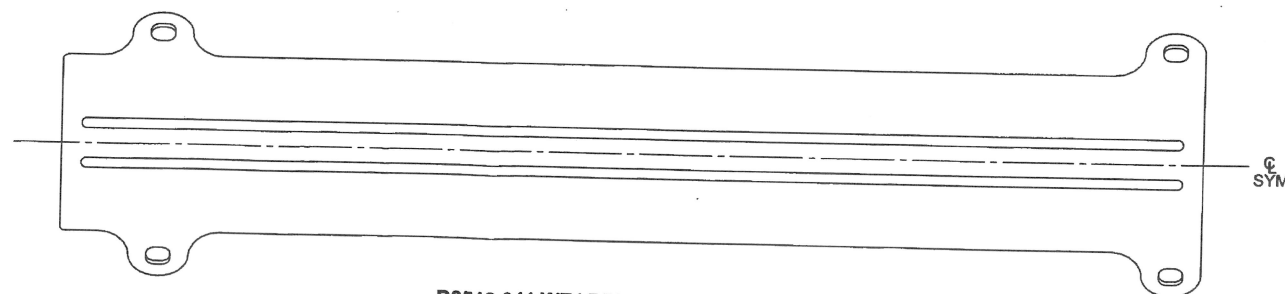
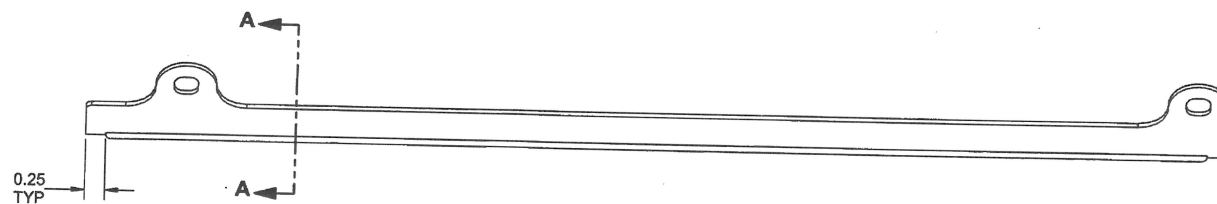
RELEASED
2013-12-10
WP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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SECTION A-A
SCALE 1:1.5



D3512-041 WEARPLATE ASSY

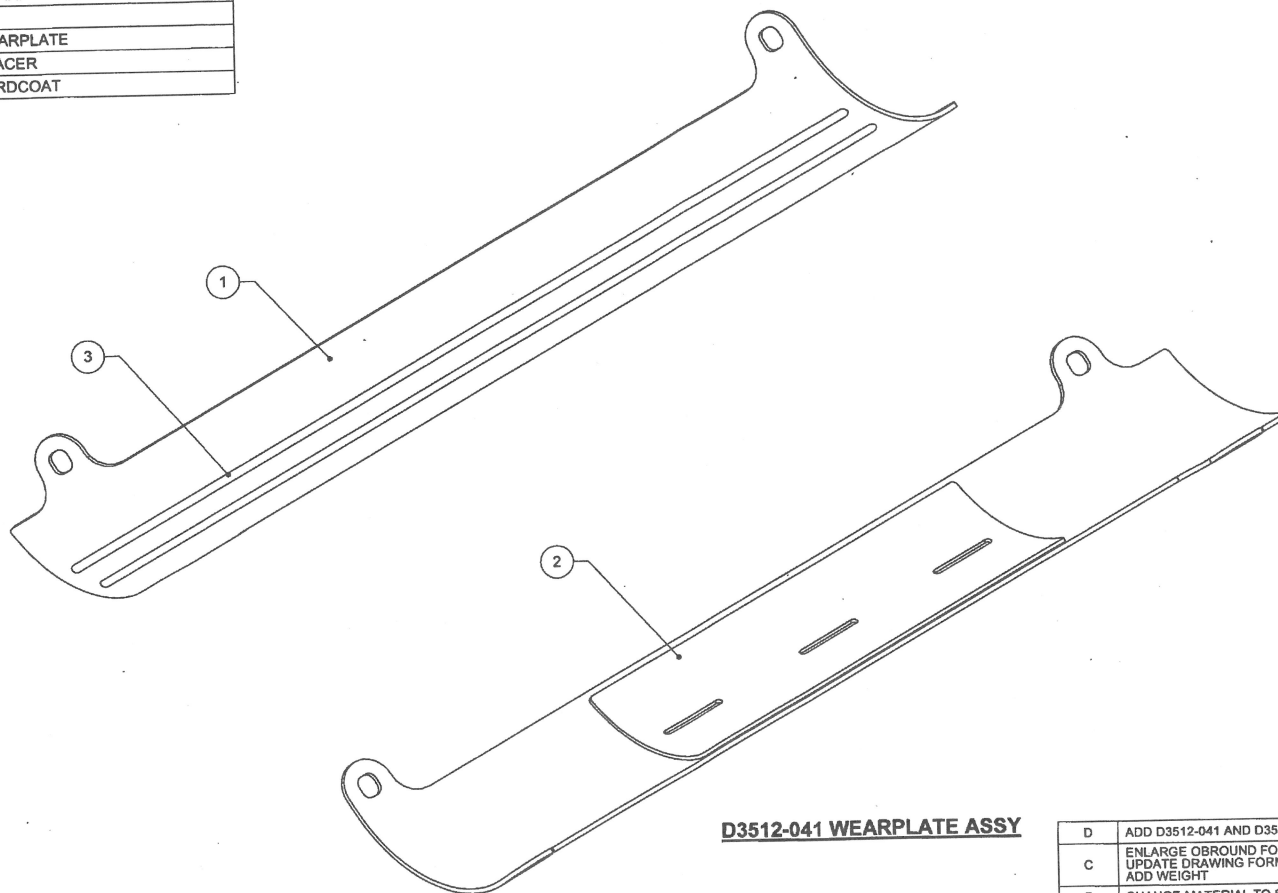
UNDER REVIEW
URF18-745 SAD 18-06-19

RELEASED
2013-12-10

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.94 lbs
 - 8) WELDING: PER QSI 004, 2059B HARDCOAT WELD 0.063 TO 0.125 THK
 - 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT



D3512-041 WEARPLATE ASSY

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2013-12-10

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D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
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